In the Claims:

1. (CURRENTLY AMENDED) A method of casting metal strip comprising:

holding a pair of ~~chilled~~ first and second casting rolls in ~~parallel~~ relationship ~~so as~~ to form a nip between them and ~~such that~~ at least one of the rolls ~~is~~ moveable ~~bodily and~~ laterally relative to the other roll,

continuously biasing said first ~~one~~ roll laterally toward the second ~~other~~ roll,

setting an initial gap between the first and second rolls at the nip ~~which is~~ less than the thickness of the strip to be initially cast,

counter rotating the first and second rolls ~~in mutually opposite directions~~ such that casting ~~the peripheral~~ surfaces of the rolls travel toward ~~downwardly at~~ the nip ~~between them~~,

pouring molten metal ~~into the nip so as~~ to form a casting pool of molten metal supported on the first and second casting rolls above the nip,

and ~~so as to produce at the nip a cast~~ casting strip delivered downwardly from the nip, having ~~the speed of rotation of the rolls being such that the strip is produced to~~ a thickness ~~which is~~ greater than the initial gap ~~set~~ between the first and second rolls by causing ~~thereby to cause said one~~ the first casting roll to move laterally bodily away from the ~~other~~ second casting roll against the continuous bias to increase the gap between the rolls to ~~accommodate~~ the thickness of the cast strip to be cast, and

continuing casting to produce strip at said thickness and with the gap between the first and second rolls increased beyond the initial gap.

2. (CURRENTLY AMENDED) A method as claimed in claim 1, wherein the casting ~~peripheral~~ surfaces of the first and second rolls having ~~are~~ radial negative~~ly~~ crown~~ed when cold~~ by ~~being formed~~ forming at their ~~midparts~~ central portions to a radius ~~which is~~ less than the radius of end ~~parts~~ portions of the casting ~~those~~ surfaces, and the initial gap ~~being~~ is set such that the end portions ~~parts~~ of the casting ~~peripheral~~ surfaces of casting rolls are spaced apart by no more than 1.5mm.

3. (CURRENTLY AMENDED) A method as claimed in claim 2, wherein the initial gap ~~spacing~~ between the end portions ~~parts~~ of the casting rolls is between ~~in the range~~ 0.5 and ~~to~~ 1.4mm.

4. (TWICE AMENDED, THE SECOND TIME CURRENTLY) A method as claimed in claim 2, wherein the radial negative crown for each casting roll is between about ~~in the range~~ 0.1 and ~~to~~ 1.5mm.

5. (TWICE AMENDED, THE SECOND TIME CURRENTLY) A method as claimed in claim 1, wherein the second casting ~~said other~~ roll is held against lateral ~~bodily~~ movement, and the first casting ~~said one~~ roll is mounted on a pair of moveable roll carriers to ~~which~~ allow said first ~~one~~ roll to move ~~bodily~~ laterally ~~of the other roll~~ and ~~said one roll is~~ be continuously biased laterally toward the second casting ~~other~~ roll by application of biasing

forces to the moveable rolls carriers.

6. (TWICE AMENDED, THE SECOND TIME CURRENTLY) A method as claimed in claim 1, wherein the initial gap between the rolls is set by positioning of a stop to limit lateral ~~bodily~~ movement of said first casting ~~one~~ roll toward the second casting roll ~~other~~.

7. (CURRENTLY AMENDED) A method as claimed in claim 6, wherein the stop ~~means is a stop which~~ is set ~~so as~~ to be engaged by one or both of the moveable roll carriers.

8. (CURRENTLY AMENDED) A method as claimed in claim 3, wherein the radial negative crown for each casting roll is between about ~~in the range~~ 0.1 and ~~to~~ 1.5mm.

9. (CURRENTLY AMENDED) A method as claimed in claim 2, wherein ~~said other~~ the second casting roll is held against lateral ~~bodily~~ movement, and the first casting ~~said one~~ roll is mounted on a pair of moveable roll carriers to ~~which~~ allow said ~~one~~ first roll to move ~~bodily~~ laterally ~~of the other roll~~ and be ~~said one roll is~~ continuously biased laterally toward the second ~~other~~ roll by application of biasing forces to the moveable rolls carriers.

10. (CURRENTLY AMENDED) A method as claimed in claim 3, wherein the second casting ~~said other~~ roll is held against lateral ~~bodily~~ movement, and the first casting ~~said one~~ roll is mounted on a pair of moveable roll carriers to ~~which~~ allow said other ~~one~~ roll to move ~~bodily~~ laterally ~~of the other roll~~ and be ~~said one roll is~~ continuously biased laterally toward the second ~~other~~ roll by application of biasing forces to the moveable rolls carriers.

11. (CURRENTLY AMENDED) A method as claimed in claim 4, wherein the second casting ~~said other~~ roll is held against lateral ~~bodily~~ movement, and the first casting ~~said one~~ roll is mounted on a pair of moveable roll carriers to ~~which~~ allow said first ~~one~~ roll to move ~~bodily~~ laterally ~~of the other roll~~ and be ~~said one roll is~~ continuously biased laterally toward the second ~~other~~ roll by application of biasing forces to the moveable rolls carriers.

12. (CURRENTLY AMENDED) A method as claimed in claim 8, wherein the second casting ~~said other~~ roll is held against lateral ~~bodily~~ movement, and the first casting ~~said one~~ roll is mounted on a pair of moveable roll carriers to ~~which~~ allow said first ~~one~~ roll to move ~~bodily~~ laterally ~~of the other roll~~ and be ~~said one roll is~~ continuously biased laterally toward the second ~~other~~ roll by application of biasing forces to the moveable rolls carriers.

13. (NEW) A method as claimed in claim 2, wherein the initial gap between the rolls is set by positioning of a stop to limit bodily movement of said first casting ~~one~~ roll toward the second casting roll ~~other~~.

14. (NEW) A method as claimed in claim 3, wherein the initial gap between the rolls is set by positioning of a stop to limit bodily movement of said first ~~one~~ roll toward the second roll ~~other~~.

15. (NEW) A method as claimed in claim 4, wherein the initial gap between the rolls is set by positioning of a stop to limit bodily movement of said first ~~one~~ roll toward the

second roll ~~other~~.

16. (NEW) A method as claimed in claim 8, wherein the initial gap between the rolls is set by positioning of a stop to limit bodily movement of said first ~~one~~ roll toward the second roll ~~other~~.

17. (CURRENTLY AMENDED) A method as claimed in claim 13, wherein the stop ~~is a stop which~~ is set so as to be engaged by one or both of the moveable roll carriers.

18. (CURRENTLY AMENDED) A method as claimed in claim 14, wherein the stop ~~is a stop which~~ is set so as to be engaged by one or both of the moveable roll carriers.

19. (CURRENTLY AMENDED) A method as claimed in claim 15, wherein the stop ~~is a stop which~~ is set so as to be engaged by one or both of the moveable roll carriers.

20. (CURRENTLY AMENDED) A method as claimed in claim 16, wherein the stop ~~is a stop which~~ is set so as to be engaged by one or both of the moveable roll carriers.

21. (NEW) A method as claimed in claim 1, wherein said first ~~one~~ roll is continuously biased laterally toward the second ~~other~~ roll by a spring mechanism.

22. (NEW) A method as claimed in claim 1, wherein said first ~~one~~ roll is continuously biased laterally toward the second ~~other~~ roll by a hydraulic mechanism.

23. (NEW) A method as claimed in claim 1, wherein said first ~~one~~ roll is continuously biased laterally toward the second ~~other~~ roll by a servo mechanism.